

Work Order ID 142101

February 25, 2016 9:46:14 AM

142101

Page 1

Item ID: D4820-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fpc Clip Assembly
 Start Date: 2/29/2016 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 3/14/2016 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: SU Date: 20160225 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4820	A

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

80X _____ 16/03/03
 DAS 36 989

110		0.00							
110									
Small Fab	Memo	0.03							
Small Fab	Assemble as per dwg and grind rivet flush as shown								

80X _____ 16/03/03
 DAS 36 989

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.03							
Quality Control									

80X _____
 DAS 38 989
 MAR 03 2016

Work Order ID 142101***142101***

Page 2

Item ID: D4820-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fpc Clip Assembly

Start Date: 2/29/2016 Start Qty: 80.00

80

Cust Item ID:

Required Date: 3/14/2016 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St 129

0.00

130

Packaging

Memo

0.01

Packaging

DAS
6
3-89

MAR 03 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.13

Quality Control

MCS MAR 03 2016MCS MAR 03 2016

Picklist Print

February 25, 2016 9:46:20 AM

Page 1

Work Order ID: 142101

142101

Parent Item: D4820-041

D4820-041

Parent Item Name: Fpc Clip Assembly

Start Date: 2/29/2016

Required Date: 3/14/2016

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4820-1 *D4820-1* Fpc Clip Base		Manufactured	No				Each	52.0000		80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				52					
				121573				52					
D4820-3 *D4820-3* Fpc Clip Profile		Manufactured	No				Each	1.0000		80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
				129135				1					
MS20426AD4-4 *MS20426AD4-4* Rivet		Purchased	No				Each	4,994.000		80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2297					
				125445				2297					
				ST312				2697					
				m132536				2697					

DAS
36
9-89

16/03/03
3142103 (28)

DAS
36
9-89

16/03/03
3142104 (72)

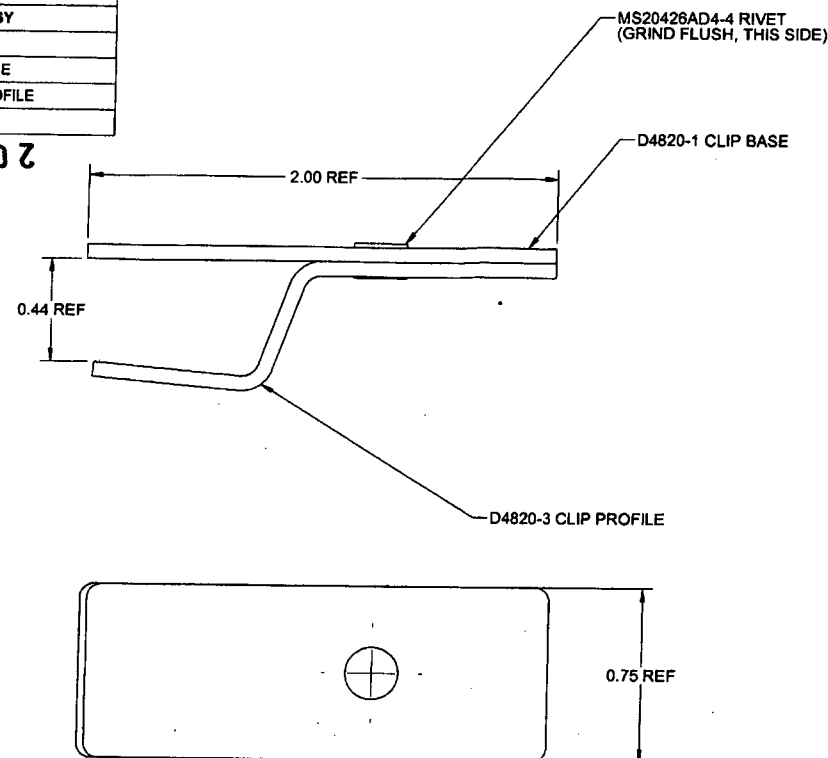
DAS
36
9-89

16/03/03

80

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET

20160225



D4820-041 CLIP ASSY

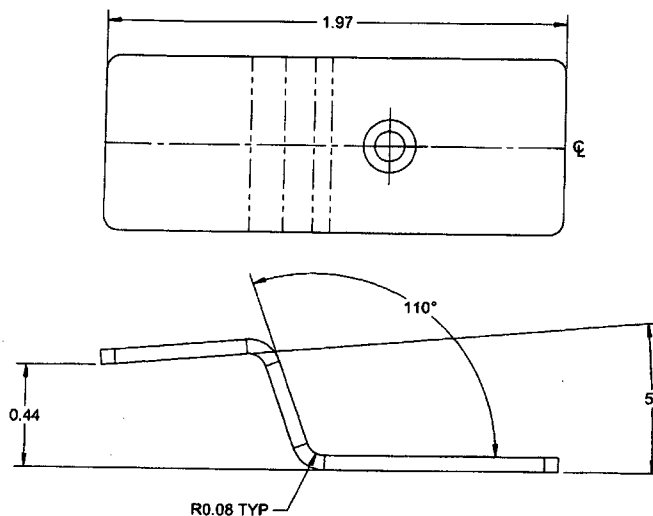
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

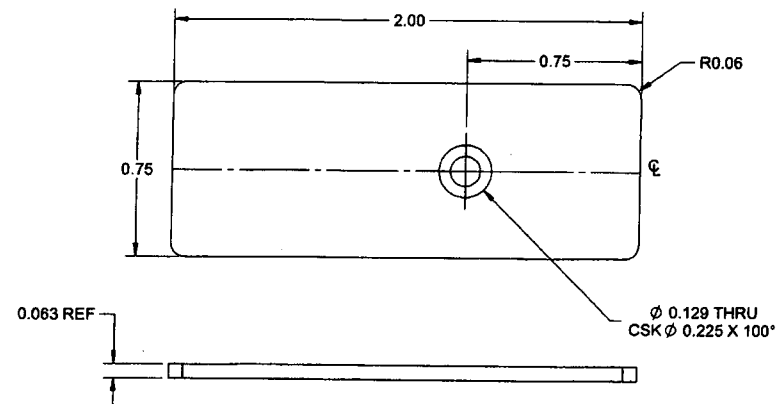
RELEASED
2013-04-18

SA 142101

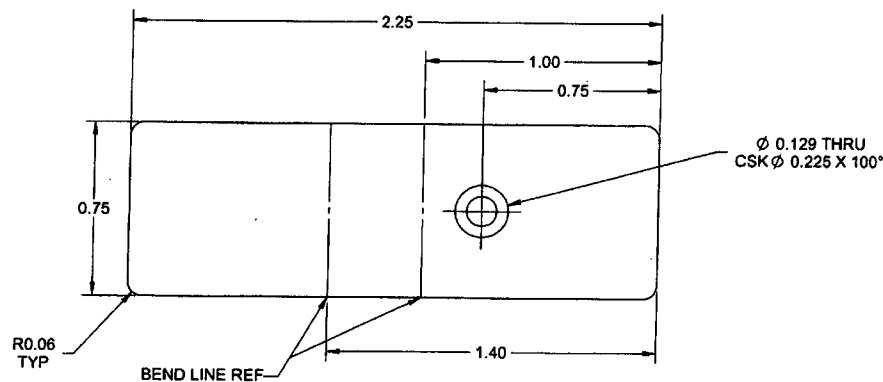
A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB	REV. A	
CHECKED	AP	DRAWING NO.	SHEET 1 OF 2
MFG. APPR.	AP	D4820	SCALE
APPROVED	AP	TITLE	NTS
DE APPR.	AP	CLIP ASSY	
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S16GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

RELEASED
2013-04-18

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			